

Date: Friday, 2/23/2007 8:31:30 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH ASSEMBLY
Job Number	: 30880		
Estimate Number	: 10303		
P.O. Number	: N/A	Part Number	: D2586
This Issue	: 2/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2586 REVD
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29021	Drawing Revision	: D
	Type : PURCHASED PARTS	Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	:	Qty:	100 Um: Each
Comment	: Est 02.01.31 Added Inspect level 21 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3171

Possible Supplier: Southco, P/N: C2-32-25

Certification Required

C 207/02/26 (100)

2.0	C23225	DOOR LATCH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
 DOOR LATCH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

1-Receive and inspect for transit damage

2-Attach certification

3-Stock Keys as: C2-32-25 Keys

4-Discard hardware

C 207/13/15 (100)

4.0	D30157	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
1	D3015-7	Lock Nut	

M 9024 x 4 ←

B 26324X13

B 30915X87

Not in Inventory

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/13/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 2/23/2007 8:31:30 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 30880

Part Number: D2586

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

SAD

07/03/19

(100)

2-Counterface as per Dwg D2586

SA

02/03/14

(100)

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

ml 07/03/20 x100

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/20 (100)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

07/03/20

07/03/20

(100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(100)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/20

Job Completion



07/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

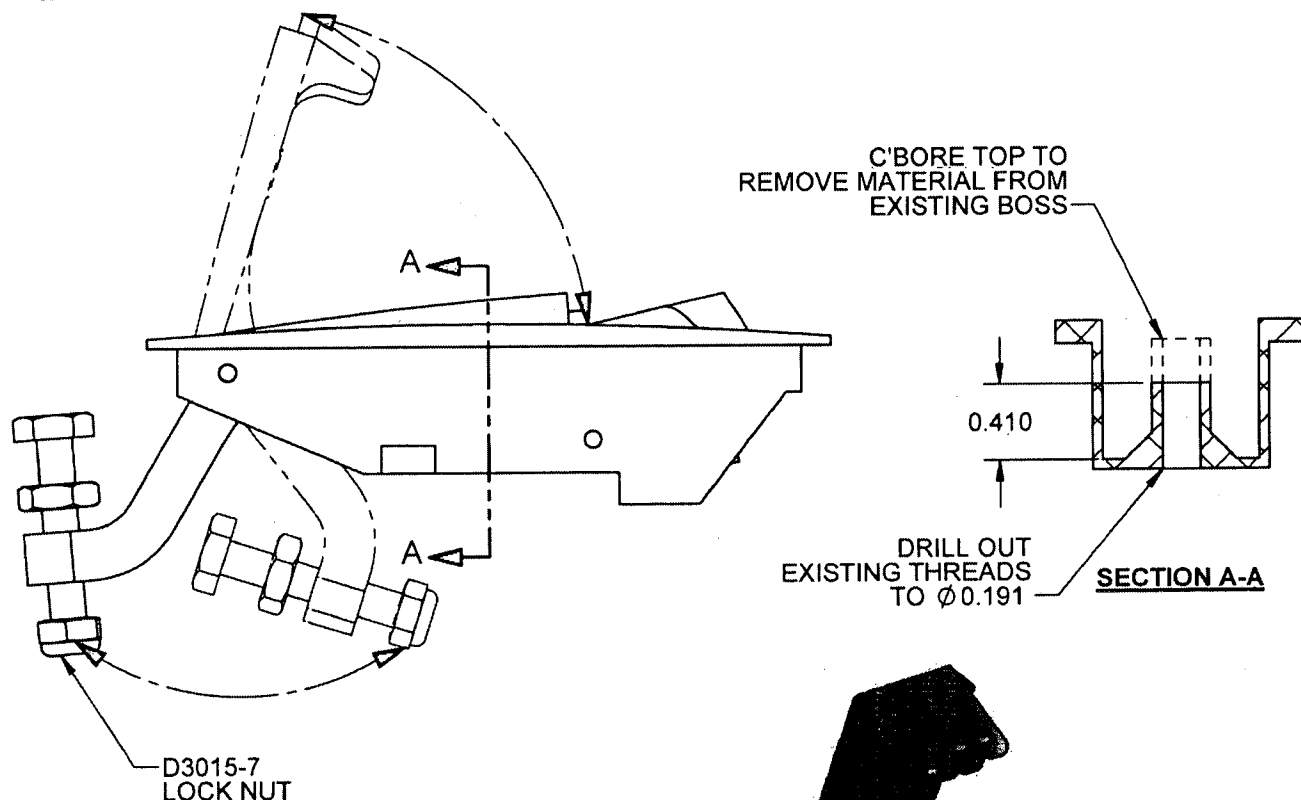
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <b>KE</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D2586</b>	REV. D SHEET 1 OF 1
DATE <b>06.10.19</b>		TITLE <b>DOOR LATCH</b>	SCALE 1:1
REV	DATE	DESCRIPTION	
A	96.07.15	NEW ISSUE	
B	97.07.23	CHANGED C'BORE DEPTH	
C	97.09.03	REVISED C'BORE DEPTH	
D	06.10.19	ADD D3015-7 P/N; UPDATE DRAWING	

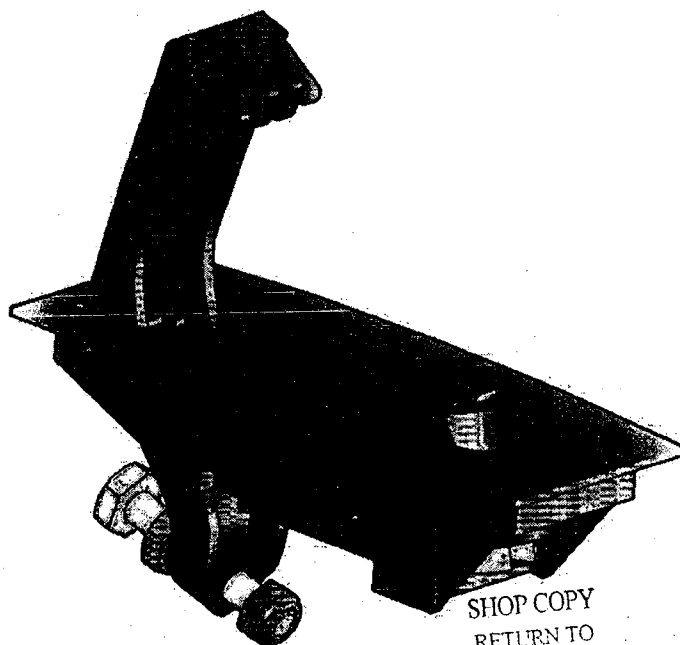
RELEASED  
06.12.22



### D2586 DOOR LATCH

#### NOTES:

- 1) MAKE FROM SOUTHCO P/N: C2-32-25
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **30880**

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Trans Continental Hardware  
1370 William St. Suite 4  
Buffalo, New York 14206

Trans Continental Hardware  
10552 King William Drive  
Dallas, TX 75220

1-800-465-6281  
www.tchweb.com



## **CERTIFICATE OF COMPLIANCE**

Date: March 16, 2007

Customer Name: Dart Aerospace Ltd

Customer P.O. No.: 3171

TCH Order No.: 71695

Invoice No.: 87795

Date shipped: 03/14/07

TCH Part No.: C2-32-25

Item Description: Black Lever Latch, Raised Trigger

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature: Roberto Rivas

Title: Indvs frnal CSR